

IN THE CLAIMS:

1. - 69. (Canceled)

70. (New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, and a center portion between the first end and the second end, wherein a width of the second end is larger than a width of the center portion, and wherein a taper portion is formed at the second end.

71. (New) The display device according to claim 70,
wherein each of the plurality of spacer comprises resin material.

72. (New) The display device according to claim 70,
wherein the plurality of the columnar spacers is disposed regularly.

73. (New) The display device according to claim 70,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

74. (New) The display device according to claim 70,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

75. (New) The display device according to claim 70,
wherein the width of the center portion is 20μm or less.

76. (New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, and a center portion between the first end and the second end,
wherein a width of the second end is larger than a width of the center portion,
wherein a taper portion is formed at the second end, and
wherein an angle between a tangent plane at a center portion and a surface of the second substrate is 65° to 115°.

77. (New) The display device according to claim 76,
wherein each of the plurality of spacer comprises resin material.

78. (New) The display device according to claim 76,
wherein the plurality of the columnar spacers is disposed regularly.

79. (New) The display device according to claim 76,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality
of the pixels.

80. (New) The display device according to claim 76,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

81. (New) The display device according to claim 76,
wherein the width of the center portion is 20μm or less.

82. (New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film
transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second
alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first
end and the second substrate, and a center portion between the first end and the second end,
wherein a width of the second end is larger than a width of the center portion,
wherein a taper portion is formed at the second end, and
wherein a height of the spacer is 0.5μm to 110μm.

83. (New) The display device according to claim 82,
wherein each of the plurality of spacer comprises resin material.

84. (New) The display device according to claim 82,
wherein the plurality of the columnar spacers is disposed regularly.

85. (New) The display device according to claim 82,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality
of the pixels.

86. (New) The display device according to claim 82,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

87. (New) The display device according to claim 82,
wherein the width of the center portion is 20μm or less.

88. (New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film
transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second
alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first
end and the second substrate, and a center portion between the first end and the second end,
wherein a width of the second end is larger than a width of the center portion,
wherein a taper portion is formed at the second end, and
wherein a radius of curvature of an edge between a upper surface and a side surface of
each of the plurality of spacers is 2μm or less.

89. (New) The display device according to claim 88,
wherein each of the plurality of spacer comprises resin material.

90. (New) The display device according to claim 88,
wherein the plurality of the columnar spacers is disposed regularly.

91. (New) The display device according to claim 88,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality
of the pixels.

92. (New) The display device according to claim 88,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

93. (New) The display device according to claim 88,
wherein the width of the center portion is 20μm or less.

94. (New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film
transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a plurality of spacers over the interlayer insulating film;
a first alignment film on the plurality of spacers and over the interlayer insulating
film;
a second substrate;
a second alignment film over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second
alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first
end and the first substrate, and a center portion between the first end and the second end,

wherein a width of the second end is larger than a width of the center portion, and
wherein a taper portion is formed at the second end.

95. (New) The display device according to claim 94,
wherein each of the plurality of spacer comprises resin material.

96. (New) The display device according to claim 94,
wherein the plurality of the columnar spacers is disposed regularly.

97. (New) The display device according to claim 94,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality
of the pixels.

98. (New) The display device according to claim 94,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

99. (New) The display device according to claim 94,
wherein the width of the center portion is 20μm or less.

100.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film
transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a conductive film over the substrate;
a plurality of spacers on the conductive film;
a second alignment film on the plurality of spacers and on the conductive film; and
a liquid crystal material interposed between the first alignment film and the second
alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate,

wherein a contact surface between the second alignment film and the spacer is continuously connected to a contact surface between the second alignment film and the conductive film, and

wherein a taper portion is formed at the second end.

101.(New) The display device according to Claim 100,
wherein the conductive film is a transparent conductive film.

102.(New) The display device according to claim 100,
wherein each of the plurality of spacer comprises resin material.

103.(New) The display device according to claim 100,
wherein the plurality of the columnar spacers is disposed regularly.

104.(New) The display device according to claim 100,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

105.(New) The display device according to claim 100,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

106.(New) The display device according to claim 100,
wherein the width of the center portion is 20μm or less.

107.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;

a first alignment film over the interlayer insulating film;
a second substrate;
a conductive film over the substrate;
a plurality of spacers on the conductive film;
a second alignment film on the plurality of spacers and on the conductive film; and
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate,
wherein a contact surface between the second alignment film and the spacer is continuously connected to a contact surface between the second alignment film and the conductive film,
wherein a taper portion is formed at the second end, and
wherein an angle between a tangent plane at a center portion and a surface of the second substrate is 65° to 115° .

108.(New) The display device according to Claim 107,
wherein the conductive film is a transparent conductive film.

109.(New) The display device according to claim 107,
wherein each of the plurality of spacer comprises resin material.

110.(New) The display device according to claim 107,
wherein the plurality of the columnar spacers is disposed regularly.

111.(New) The display device according to claim 107,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

112.(New) The display device according to claim 107,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

113.(New) The display device according to claim 107,
wherein the width of the center portion is 20 μ m or less.

114.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a conductive film over the substrate;
a plurality of spacers on the conductive film;
a second alignment film on the plurality of spacers and on the conductive film; and
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate,
wherein a contact surface between the second alignment film and the spacer is continuously connected to a contact surface between the second alignment film and the conductive film,
wherein a taper portion is formed at the second end, and
wherein a height of the spacer is 0.5 μ m to 110 μ m.

115.(New) The display device according to Claim 114,
wherein the conductive film is a transparent conductive film.

116.(New) The display device according to claim 114,
wherein each of the plurality of spacer comprises resin material.

117.(New) The display device according to claim 114,
wherein the plurality of the columnar spacers is disposed regularly.

118.(New) The display device according to claim 114,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality
of the pixels.

119.(New) The display device according to claim 114,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

120.(New) The display device according to claim 114,
wherein the width of the center portion is 20μm or less.

121.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film
transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a conductive film over the substrate;
a plurality of spacers on the conductive film;
a second alignment film on the plurality of spacers and on the conductive film; and
a liquid crystal material interposed between the first alignment film and the second
alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first
end and the second substrate,
wherein a contact surface between the second alignment film and the spacer is
continuously connected to a contact surface between the second alignment film and the
conductive film,

wherein a taper portion is formed at the second end, and
wherein a radius of curvature of an edge between a upper surface and a side surface of each of the plurality of spacers is $2\mu\text{m}$ or less.

122.(New) The display device according to Claim 121,
wherein the conductive film is a transparent conductive film.

123.(New) The display device according to claim 121,
wherein each of the plurality of spacer comprises resin material.

124.(New) The display device according to claim 121,
wherein the plurality of the columnar spacers is disposed regularly.

125.(New) The display device according to claim 121,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

126.(New) The display device according to claim 121,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

127.(New) The display device according to claim 121,
wherein the width of the center portion is $20\mu\text{m}$ or less.

128.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a plurality of spacers on the interlayer insulating film;
a first alignment film on the plurality of spacer and on the interlayer insulating film;
a second substrate;

a second alignment film over second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first end and the first substrate,

wherein a contact surface between the second alignment film and the spacer is continuously connected to a contact surface between the second alignment film and the interlayer insulating film, and

wherein a taper portion is formed at the second end.

129.(New) The display device according to claim 128,
wherein each of the plurality of spacer comprises resin material.

130.(New) The display device according to claim 128,
wherein the plurality of the columnar spacers is disposed regularly.

131.(New) The display device according to claim 128,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

132.(New) The display device according to claim 128,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

133.(New) The display device according to claim 128,
wherein the width of the center portion is 20μm or less.

134.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;

a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate;
a liquid crystal material interposed between the first alignment film and the second alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, a center portion between the first end and the second end, and a lower portion between the center portion and the second end,

wherein an angle between a tangent plane at a center portion and a surface of the second substrate is larger than an angle between a tangent plane at a lower portion and the surface of the second substrate.

135.(New) The display device according to claim 134,
wherein each of the plurality of spacer comprises resin material.

136.(New) The display device according to claim 134,
wherein the plurality of the columnar spacers is disposed regularly.

137.(New) The display device according to claim 134,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

138.(New) The display device according to claim 134,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

139.(New) The display device according to claim 134,
wherein the width of the center portion is 20μm or less.

140.(New) A display device comprising:
a first substrate;

a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate;
a liquid crystal material interposed between the first alignment film and the second alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, a center portion between the first end and the second end, and a lower portion between the center portion and the second end,

wherein an angle between a tangent plane at a center portion and a surface of the second substrate is larger than an angle between a tangent plane at a lower portion and the surface of the second substrate, and

wherein an angle between a tangent plane at a center portion and a surface of the second substrate is 65° to 115° .

141.(New) The display device according to claim 140,
wherein each of the plurality of spacer comprises resin material.

142.(New) The display device according to claim 140,
wherein the plurality of the columnar spacers is disposed regularly.

143.(New) The display device according to claim 140,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

144.(New) The display device according to claim 140,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

145.(New) The display device according to claim 140,
wherein the width of the center portion is 20 μ m or less.

146.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate;
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, a center portion between the first end and the second end, and a lower portion between the center portion and the second end,
wherein an angle between a tangent plane at a center portion and a surface of the second substrate is larger than an angle between a tangent plane at a lower portion and the surface of the second substrate, and
wherein a height of the spacer is 0.5 μ m to 110 μ m.

147.(New) The display device according to claim 146,
wherein each of the plurality of spacer comprises resin material.

148.(New) The display device according to claim 146,
wherein the plurality of the columnar spacers is disposed regularly.

149.(New) The display device according to claim 146,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

150.(New) The display device according to claim 146,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

151.(New) The display device according to claim 146,
wherein the width of the center portion is 20μm or less.

152.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate;
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, a center portion between the first end and the second end, and a lower portion between the center portion and the second end,
wherein an angle between a tangent plane at a center portion and a surface of the second substrate is larger than an angle between a tangent plane at a lower portion and the surface of the second substrate, and
wherein a radius of curvature of an edge between a upper surface and a side surface of each of the plurality of spacers is 2μm or less.

153.(New) The display device according to claim 152,
wherein each of the plurality of spacer comprises resin material.

154.(New) The display device according to claim 152,
wherein the plurality of the columnar spacers is disposed regularly.

155.(New) The display device according to claim 152,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality
of the pixels.

156.(New) The display device according to claim 152,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

157.(New) The display device according to claim 152,
wherein the width of the center portion is 20μm or less.

158.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film
transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a plurality of spacers over the interlayer insulating film;
a first alignment film on the plurality of spacers and over the interlayer insulating
film;
a second substrate;
a second alignment film over the second substrate;
a liquid crystal material interposed between the first alignment film and the second
alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first
end and the first substrate, a center portion between the first end and the second end, and a
lower portion between the center portion and the second end,

wherein an angle between a tangent plane at a center portion and a surface of the first substrate is larger than an angle between a tangent plane at a lower portion and the surface of the first substrate.

159.(New) The display device according to claim 158,
wherein each of the plurality of spacer comprises resin material.

160.(New) The display device according to claim 158,
wherein the plurality of the columnar spacers is disposed regularly.

161.(New) The display device according to claim 158,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

162.(New) The display device according to claim 158,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm².

163.(New) The display device according to claim 158,
wherein the width of the center portion is 20μm or less.

164.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, and a center portion between the first end and the second end, wherein a width of the second end L_2 and a width of the center portion L_1 are set in the range of $1 < L_2 / L_1 < 2.5$.

165.(New) The display device according to claim 164, wherein each of the plurality of spacer comprises resin material.

166.(New) The display device according to claim 164, wherein the plurality of the columnar spacers is disposed regularly.

167.(New) The display device according to claim 164, wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

168.(New) The display device according to claim 164, wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

169.(New) The display device according to claim 164, wherein the width of the center portion is $20\mu\text{m}$ or less.

170.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;

a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, and a center portion between the first end and the second end,

wherein a width of the second end L_2 and a width of the center portion L_1 are set in the range of $1 < L_2 / L_1 < 2.5$, and

wherein an angle between a tangent plane at a center portion and a surface of the second substrate is 65° to 115° .

171.(New) The display device according to claim 170,
wherein each of the plurality of spacer comprises resin material.

172.(New) The display device according to claim 170,
wherein the plurality of the columnar spacers is disposed regularly.

173.(New) The display device according to claim 170,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

174.(New) The display device according to claim 170,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

175.(New) The display device according to claim 170,
wherein the width of the center portion is $20\mu\text{m}$ or less.

176.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;

an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;

wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, and a center portion between the first end and the second end,

wherein a width of the second end L_2 and a width of the center portion L_1 are set in the range of $1 < L_2 / L_1 < 2.5$, and

wherein a height of the spacer is $0.5\mu\text{m}$ to $110\mu\text{m}$.

177.(New) The display device according to claim 176,
wherein each of the plurality of spacer comprises resin material.

178.(New) The display device according to claim 176,
wherein the plurality of the columnar spacers is disposed regularly.

179.(New) The display device according to claim 176,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

180.(New) The display device according to claim 176,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

181.(New) The display device according to claim 176,
wherein the width of the center portion is $20\mu\text{m}$ or less.

182.(New) A display device comprising:
a first substrate;

a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a first alignment film over the interlayer insulating film;
a second substrate;
a plurality of spacers over the second substrate;
a second alignment film on the plurality of spacers and over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the second substrate, and a center portion between the first end and the second end,
wherein a width of the second end L_2 and a width of the center portion L_1 are set in the range of $1 < L_2 / L_1 < 2.5$, and
wherein a radius of curvature of an edge between an upper surface and a side surface of each of the plurality of spacers is $2\mu\text{m}$ or less.

183.(New) The display device according to claim 182,
wherein each of the plurality of spacer comprises resin material.

184.(New) The display device according to claim 182,
wherein the plurality of the columnar spacers is disposed regularly.

185.(New) The display device according to claim 182,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

186.(New) The display device according to claim 182,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

187.(New) The display device according to claim 182,
wherein the width of the center portion is $20\mu\text{m}$ or less.

188.(New) A display device comprising:
a first substrate;
a plurality of pixels arranged in a matrix, each of which comprises a thin film transistor over the first substrate;
an interlayer insulating film over the thin film transistor;
a plurality of spacers over the interlayer insulating film;
a first alignment film on the plurality of spacers over the interlayer insulating film;
a second substrate;
a second alignment film over the second substrate; and
a liquid crystal material interposed between the first alignment film and the second alignment film;
wherein each of the plurality of spacers has a first end, a second end between the first end and the first substrate, and a center portion between the first end and the second end,
wherein a width of the second end L_2 and a width of the center portion L_1 are set in the range of $1 < L_2 / L_1 < 2.5$.

189.(New) The display device according to claim 188,
wherein each of the plurality of spacer comprises resin material.

190.(New) The display device according to claim 188,
wherein the plurality of the columnar spacers is disposed regularly.

191.(New) The display device according to claim 188,
wherein each of the plurality of spacers is disposed for every six pixels of the plurality of the pixels.

192.(New) The display device according to claim 188,
wherein the plurality of spacer is disposed at a density of 10 to 200 ones per mm^2 .

193.(New) The display device according to claim 188,
wherein the width of the center portion is 20μm or less.